Work Order ID 59974 Tuesday, June 22, 2010 10:15:00 AM Accept D206-667-203 Item ID: **Revision ID:** Stop Crosstube Aft Item Name: Cust Item ID: Start Qty: 1.00 6/22/2010 **Start Date:** Req'd Qty: 1.00 Customera Required Date: 7/20/2010 Reference: Start Run Tooling: Date: **Process Plan:** Approvals: Stop SPC (Y/N): Date: Date: QC: Plan Reject Reject Tool# Accept Set Up/ **Tool ID** Sequence ID/ Operation Number Qty ' Code Qty Run Hours Work Center ID Description **Revision Nbr** Draw Nbr Rev C D206-667-243 0.00 100 DOCUMENT CONTROL 0.00 DC Memo Photocopy bluefile and create labels as per PPP D206-667-203 CHG003 Document Control 0.00 110 BENDING MACHINE - CROSSTUBES 0.00 CNC Bend 2 Memo Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF CNC Alpha 160 Bender QC15- Crosstube Dimensional Check 0.00 120

0.00

Memo

Quality Control

Page 1

Insp.

Stamp

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval** Approval QC Inspector DATE **STEP PROCEDURE CHANGE** Qty Ву **Date** Chief Eng / Prod Mgr

Disposition: Scupp

Part No:	1206-667-203	PAR #: _
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Resolution: Scrpp

NCR: (es) No DQA

QA: N/C Closed:

Date: <u>/0 0 字 0 份</u>

NCR: 5	9974	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	CTED	Description of NC		Corrective Action Section B		Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
iología	# 110	tune was crushed in Berker about 12" from cuff on in sine of Bend. operator was on appropria	10. Dept	-> tuhe is how not some- able. Scrap+ Desty no replace	Sh.	500	ኔ ጉ	W27-26	5/09/4
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Tuesday, June 22, 2010 10:15:00 AM

Item ID) :
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D206-667-203

Revision ID:

Required Date: 7/20/2010

Item Name:

Crosstube Aft

Start Date:

6/22/2010

Start Qty: 1.00

Req'd Qty: 1.00



Accept



Cust Item ID:

Customer:

Tool ID

Setup Start

Stop



Run

Accept

Reference:

Approvals:

Process	Plan:

QC:

Date: Date: Tooling:

SPC (Y/N):

Date:

Tool # Plan

Date:

Code | Qty

Start



Stop

Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

130



Crosstubes

Crosstubes

Operation Description Set Up/ **Run Hours**

0.00

Crosstubes

Memo

0.00

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 and drill table DT8577. Locate hole #6 for towers as per QSI 10. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig D 18789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-67-243.

9 -Scribe part # and batch # dsing vibrating stylus as per Dwg D206-667-243 Inside of Cuff(Donot engrave on outside of tube)

10 -Deburr & Inspect for surface damage. Repair damage within limits as per





W/O:			V	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Page 1

Tuesday, June 2	2, 2010 10:1.	5:00 AM							rage 3
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Item Name:	Crosstube Aft				÷			Stop	
Start Date: Required Date: Reference:	6/22/2010 : 7/20/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Iten Custome				
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		Dwg D206-667 -2 4	3	/					
		Crosstubes Chemical Con	version	0.00					
HandFXtube Hand Finishing Cro	sstubes	Memo		0.00					
		QC3- Inspect Part Finish		0.00					
QC Quality Control		Memo	/	0.00		' ()			
		QC5- Inspect part comple	teness to step on W	//O 0.00					
QC Quality Control		Memo		0.00	:			· · · · · · · · · · · · · · · · · · ·	

W/O:	WORK ORDER CHANGES									
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Page 4

Item ID:

D206-667-203

Accept

Setup Start



Stop



Item Name: **Start Date:**

Revision ID:

Crosstube Aft

6/22/2010

Start Qty: 1.00

Required Date: 7/20/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

QC:

SPC (Y/N):

Date:

Date:

Run



Stop

Start

Sequence ID/ **Work Center ID**

170



Outsource2

Outsource process - NDT

Description

Operation

Outsource process - NDT per QSI038 4.1

_____ Date:___

Set Up/ **Run Hours**

0.00

0.00

0.00

0.00

Tool ID Tool # Plan

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O:

Memo

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

180



Packaging

Packaging

Packaging

Memo

Ensure copy of NDT results attached to work order.

190

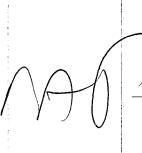
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Ensure results are as per Dwg D206-667-243





W/O:	0: WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			 							
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Work Order ID 59974 Page 5 Tuesday, June 22, 2010 10:15:00 AM D206-667-203 Item ID: Accept Setup Start **Revision ID:** Item Name: Crosstube Aft Stop **Start Date:** 6/22/2010 Start Qty: 1.00 Cust Item ID: Required Date: 7/20/2010 Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Process Plan: _____ Date: ____ Tooling: Date: QC: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty. Number Stamp 200 0.00 SprayPaint SprayPaint Memo **Spray Painting** 1-Prime inside and outside crosstube as per QSI 005 1.2 2-Paint outside crosstube with White Imron as per SI 005 4.2 PRIME: Start Time: Fininsh Time: PAINT: Start Time: Finish Time: 210 QC14- Inspect Spray Paint 0.00 Memo 0.00 Quality Control Wrap in plastic bag to protect from scratches

W/O:			W	ORK ORDER CHANG	ES					
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Work Order ID 59974 Tuesday, June 22, 2010 10:15:00 AM Page 6 Item ID: D206-667-203 Accept Setup Start **Revision ID: Item Name:** Crosstube Aft Stop **Start Date:** 6/22/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 7/20/2010 Req'd Qty: 1.00 **Customer:** Reference: Process Plan: _____ Date: ____ Approvals: Run Start Tooling: Date: Date:_ SPC (Y/N): Stop Date: Sequence ID/ Operation Set Up/ TooMD Work Center ID Tool # Plan Accept Reject Description Reject Insp. **Run Hours** Code Qty **Qty** Number Stamp 220 0.00 Crosstubes Crosstubes Memo 0.00 Crosstubes 1-Install nut plates as per Dwg D206-667-243. . 230

1188

Crosstubes

Crosstubes

Skidtubes

Memo

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up.

0.00

A/R Magnobond 6398 :

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb



W/O: WORK ORDER CHANGES									
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Work Order ID 59974 Tuesday, June 22, 2010 10:15:00 AM Page 7 Item ID: D206-667-203 Accept Setup Start **Revision ID:** Item Name: Crosstube Aft Stop **Start Date:** 6/22/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 7/20/2010 Req'd Qty: 1.00 **Customer:** Reference: Approvals: Run Start Process Plan: _____ Date: ____ Tooling: Date:_ QC: ______ Date: _____ SPC (Y/N): Stop Date:_ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Work Center ID Accept Reject Reject Description Insp. Run Hours Code Qty Qty Number Stamp 240 QC5- Inspect part completeness to step on W/O 0.00 Memo Quality Control 250 Pick Kit 0.00 Packaging Memo 0.00 Packaging 260 QC4- 100% Inspect kits for completeness Memo 0.00 Quality Control

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Page 8

Tuesday, June 2.	2, 2010 10:1.	5:00 AM					l I			
Item ID: Revision ID:	D206-667-20	03		Accept				Setup Sta	rt	
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Start Date:	6/22/2010	Start Qty: 1.00			Cust Item 1	ID.	į		* ********	/ IIM IIM 780 1
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Sequence ID/ Work Center II 270)	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pla	Accept ode Qty	Reject Qty	-	Insp. Stamp
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Packaging		Memo		0.00		A				
Packaging		Identify and Location: PPP Rev:	pack for shipping as per	PPP D206-667-203) }				
280		QC21- Final Inspection -	Work Order Release	0.00)		
QC Quality Control		Memo		0.00						
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Work Order ID: 59974

Parent Item:

D206-667-203

Parent Item Name:

Crosstube Aft



Last

Location

Start Date: 6/22/2010

Required Date: 7/20/2010

Required Qty: 1.00

Start Qty: 1.00

Comments:

IPP Rev: $F \Box 05.09.01 \Box$ Add holes for compatibility with Bell Skidtubes \Box KJ/JLM

IPP Rev:G 08-06-03

update as per DSI9415 (ECN1198) DD verified by:ec IPP Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC

IPP Rev:I IPP Rev J

Item ID

Replacement Mfg/

09.01.06 ECN 08-562

08-12-15 add magnobond DD verified by:EC EC verified by:DD

Primary

	; -				
Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status

AN960JD516

Item Name

NAS1149D0563J Purchased

Item Location No

Bin

100

Each 0.0000

18 18

Washer

D206-667-203TRN

Component Item ID/

Manufactured

Purch

220

Route

Seq ID

Each 3.0000

Unit of

Measure

Crosstube Turning Detail

Location LG



Loc Oty

Loc Code

D2873-043

Nut Plate Assembly

Manufactured

No

220

Each

48.0000

Location Loc Oty Loc Code LG 48 53966 20 56466 57337 20

W/O:	-		W	ORK ORDER CHANGE	S				
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Picklist Print Tuesday, June 22, 2010 10:15:04 AM	1									Page 2
Work Order ID: 59974 Parent Item: D206-667-203 Parent Item Name: Crosstube Aft)	:	Si	tart Date:	6/22/2010	Required Date: 7/20/2010
D2873-045 Nut Plate Assembly	Manufactured	No			220	Each	44.0000	Start Qty:	2	Required Qty: 1.00
D2892-1	Manufactured	No	<u>Locat</u> LG	53967 53968 57336	230	44 5 20 19	<u>Loc Code</u> 52.0000	2	2	
Support			<u>Locat</u> LG	41986 42785 53124	Loc	52 12 20	Loc Code		. 1	
D3595-063-450 RUBBER CUSHION	Manufactured	No		55787	230	7 Each	74.9790	4	4	
			<u>Locati</u> LG	53775 58161 59580	<u>Loc</u> 74.9789 5.9789		Loc Code			

Dart Aerospace Ltd	D	art	Aero	space	Ltd
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Picklist Print

Tuesday, June 22, 2010 10:15:04 AM

Page 4

Work Order ID: 59974

Parent Item:

D206-667-203

Parent Item Name: Crosstube Aft



MS21042L5

Purchased

Purchased

No

No

Start Date: 6/22/2010 Start Qty: 1.00

681.0000

Loc Code

Loc Code

Required Date: 7/20/2010 Required Qty: 1.00

Nut

Location ST139

114813

ST300

114449

Loc Oty

260

181

Each

Each 118.0000

MS21920-22

Clamp(per MIL-DTL-8783C)

Location LG

111210

114071

Loc Oty

19

99

Tuesday, June 22, 2010 10:15:04 AM

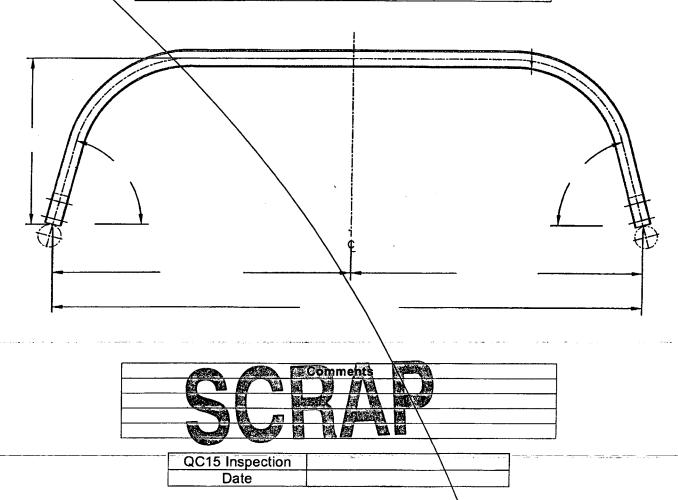
Shop Packet Print

Page 4

W/O:			V	ORK ORDER CHANGI	ES	**************************************			
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DART AEROSPACE LTD	Work Order:	39974
Description: Crosstube High Aft (206L)	Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.1



Rev	Date	Change	4 5 1 4	Revised by	Approved
Α	07.02.06	New Issue		KJ/JM	
В	09.11.17	Dwg Rev updated		KJ / A	
С	09.12.14	Dimensions update per Dwg Rev C		KJ 🛠	111
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W/O:			WORK ORDER CHANGES										
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Part Number Description -243 D206-667-243 CROSSTUBE ASSEMBLY (206L HIGH AFT) D6004-115 CROSSTUBE D2873-043 **NUT PLATE** D2873-045 NUT PLATE D2892-1 SUPPORT 6 D3595-063-450 RUBBER CUSHION MS21920-22 4 CLAMP 8 14 MS20601AD4W10 RIVET (OR NAS9302B-4-10) MAGNOBOND 6398 ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 39974

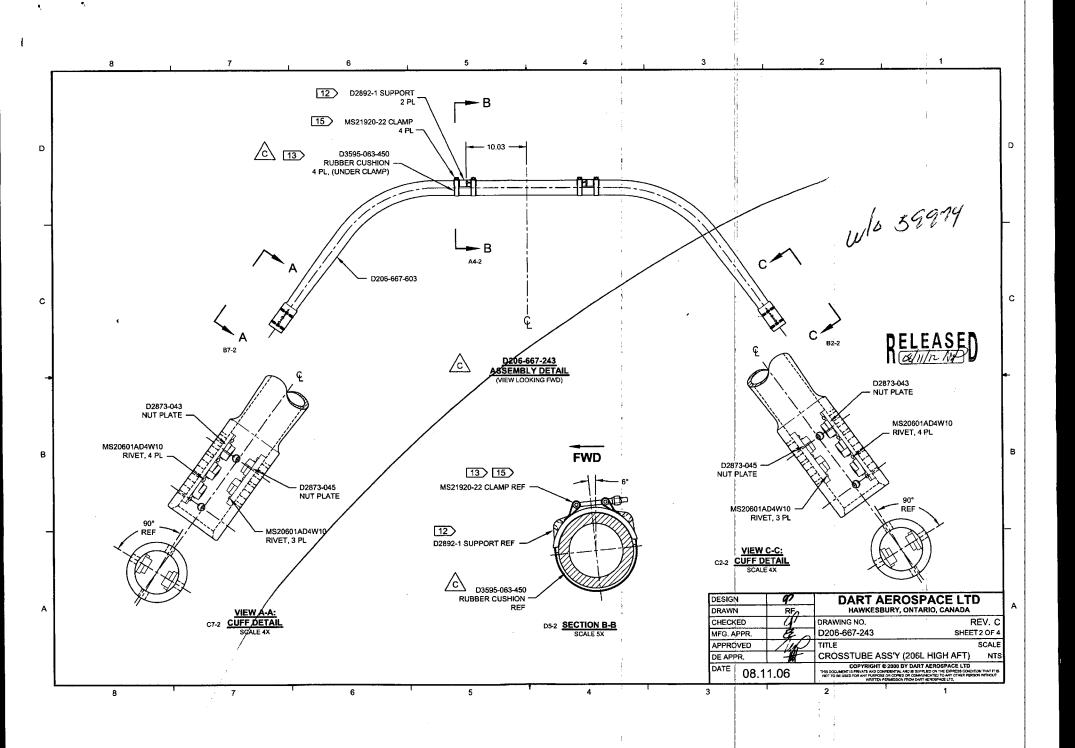
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115 FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03 TO 10.05 THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH DS95-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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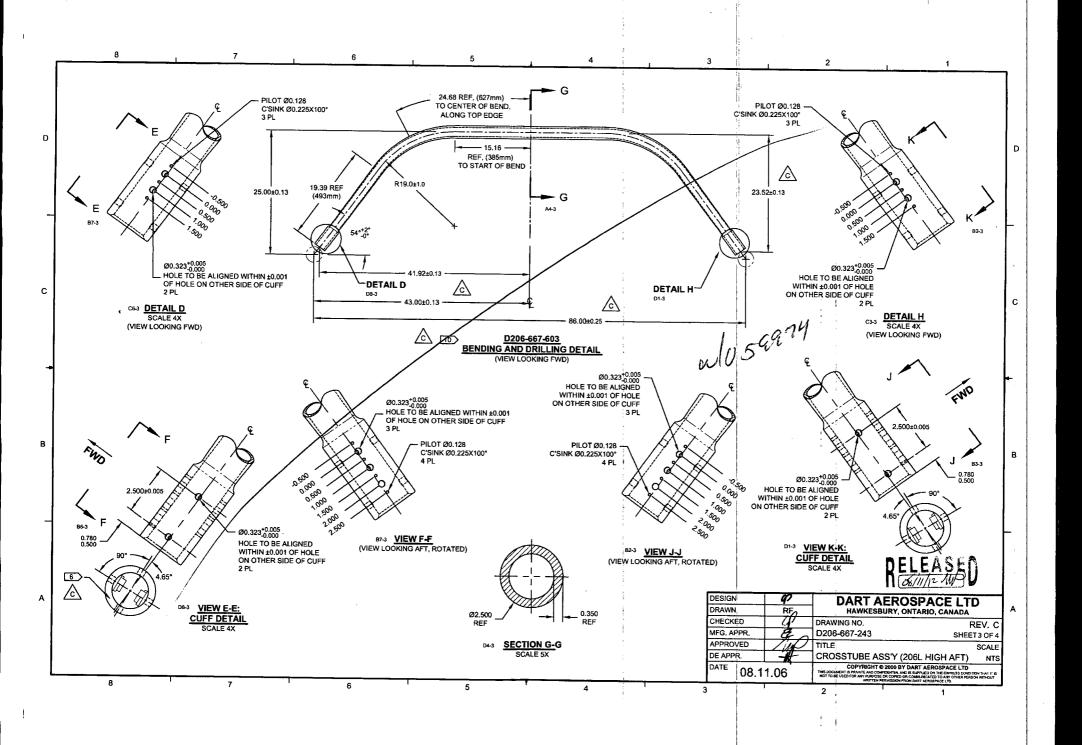
С	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.							
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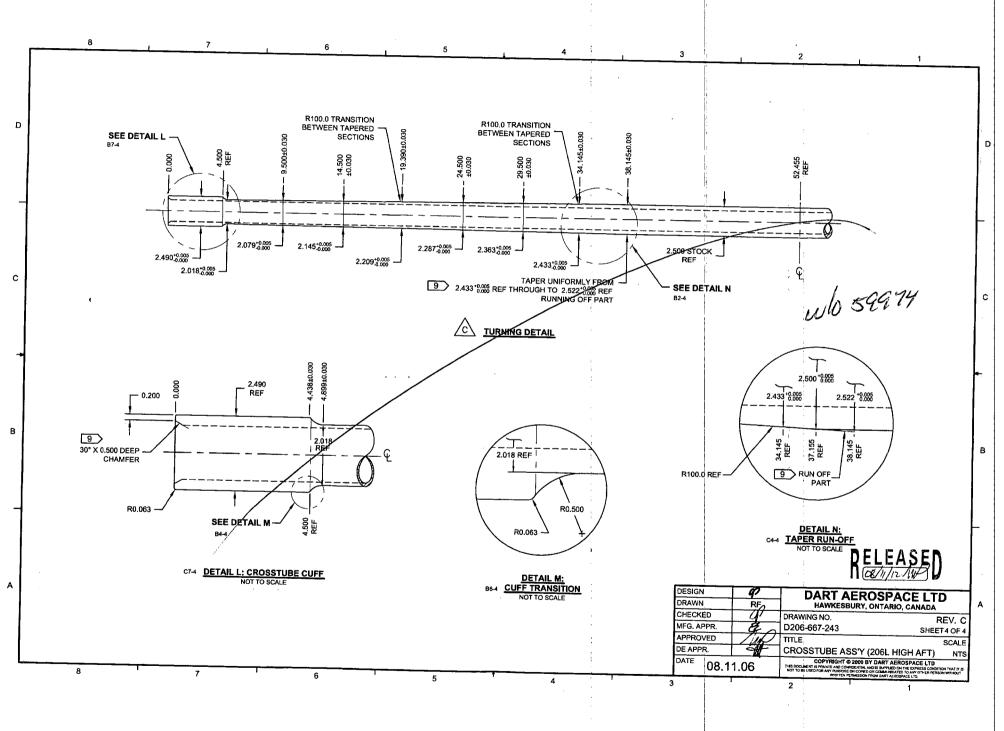


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